

Work Order ID 96958

February-13-13 7:54:14 AM

96958

Page 1

Item ID: D3795-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Ski Fwd

Start Date: 2/13/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 2/20/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3795	C								

110 0.00

110

FLOW WATER JET

Waterjet Memo 0.00

FLOW CNC Waterjet 1-Cut as per Dwg File D3795-1 Blank

2-Deburr if necessary

1 0 JmB-2-13

120 0.00

120

HAAS CNC VERTICAL MACHINING #1

HAAS 1 Memo 0.00

HAAS CNC vertical machine #1 1- Mill as per Folio FA765 Rev: AA & Dwg D3795 Rev: C

2-Deburr per dwg D3795

on 13/02/21

1 0

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Item ID: D3795-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Ski Fwd
 Start Date: 2/13/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/20/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC2- Inspect parts off machine FAI/FAIB	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	QC8- Inspect parts - second check	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									

HAI

h

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Item ID: D3795-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Ski Fwd
 Start Date: 2/13/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/20/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

13/2/21

HAC
04700

unf.
13-2-21

Picklist Print

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Page 1

Work Order ID: 96958

Parent Item: D3795-1

Parent Item Name: Ski Fwd

Start Date: 2/13/13

Required Date: 2/20/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-07-18 JLM Verified By:DD
IPP Rev:B 08-09-10 revA as per dwg (ecn 08-513) DD verf: EC IPP REV:C 12.09.06 PER DWG
REV.B DD VERF:JFS
IPP REV C:12.09-12 AS PER REV C JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10
UHMW 1" Black

Purchased

No

100

sf

631.4950

5.9376

~~6.2501053~~

Jm 3-2-13

Location

Loc Qty

Loc Code

MAT019

631.4949895

121278

12.0949895

122575

47.6

123229

53

123704

63.8

123949

26

124167

7

124380

22

124382

400

~~124380~~
124382

96958

DART AEROSPACE LTD		Work Order:
Description: Ski, Fwd Section		Part Number: D3795-1
Inspection Dwg: D3795	Rev: C	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.62	+/-0.030	6.620	✓		Vern	CNC-02
3.40	+/-0.030	3.400	✓		"	ML-06
R0.25	+/-0.030	R.250	✓		R-G	
0.050 x 45°	+/-0.010 x +/-0.5°	.040x45°	✓		Vern	ML-06
0.063 x 45°	+/-0.010 x +/-0.5°	.060x45°	✓		"	"
0.19 x 45°	+/-0.030 x +/-0.5°	.195x45°	✓		"	"
0.063 x 45°	+/-0.010 x +/-0.5°	.065x45°	✓		"	"
0.38	+0.030/-0.010	.388	✓		"	"
0.20	+0.030/-0.010	.204	✓		"	"
0.25	+0.030/-0.010	.255	✓		"	"
R0.25	+/-0.030	R.250	✓		R-G	
0.75	+0.030/-0.010	.753	✓		Vern	ML-06
0.95	+0.030/-0.010	.950	✓		"	"
0.38	+/-0.030	.380	✓		"	"
R0.63	+/-0.030	R1.630	✓		R-G	
R0.50	+/-0.030	R.500	✓		"	
R0.38	+/-0.030	R.380	✓		"	
R2.00	+/-0.030	R2.00	✓		"	
R0.50	+/-0.030	R.500	✓		"	
R0.25	+/-0.030	R.250	✓		"	
R0.13	+/-0.030	R.130	✓		"	
Ø0.261	+0.006/-0.001	Ø.261	✓		Vern	ML-06
Ø0.93	+/-0.030	Ø.930	✓		"	"
0.30	+/-0.030	.320	✓		"	"
44.69	+/-0.030	44.690	✓		M-tape	ML-08
23.56	+/-0.030	23.560	✓		"	"
14.81	+/-0.030	14.810	✓		"	"
9.625	+/-0.010	9.625	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
7.000	+/-0.010	7.000	✓		"	"
12.000	+/-0.010	12.000	✓		"	"

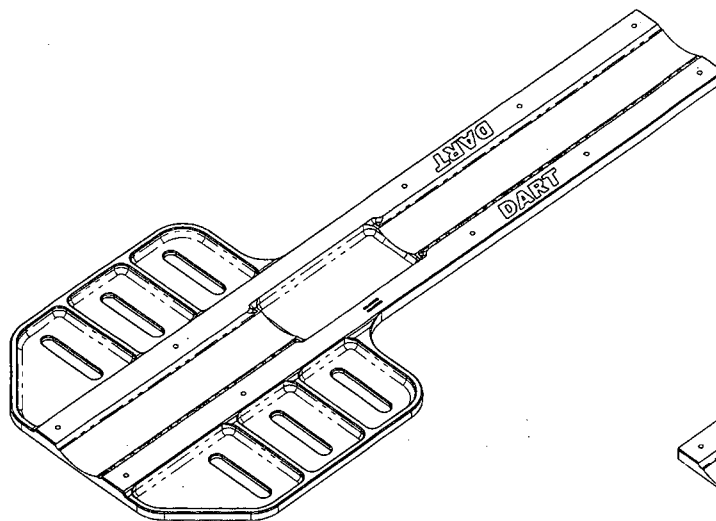
DART AEROSPACE LTD		Work Order:	
Description: Ski, Fwd Section		Part Number:	D3795-1
Inspection Dwg: D3795 Rev: C		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

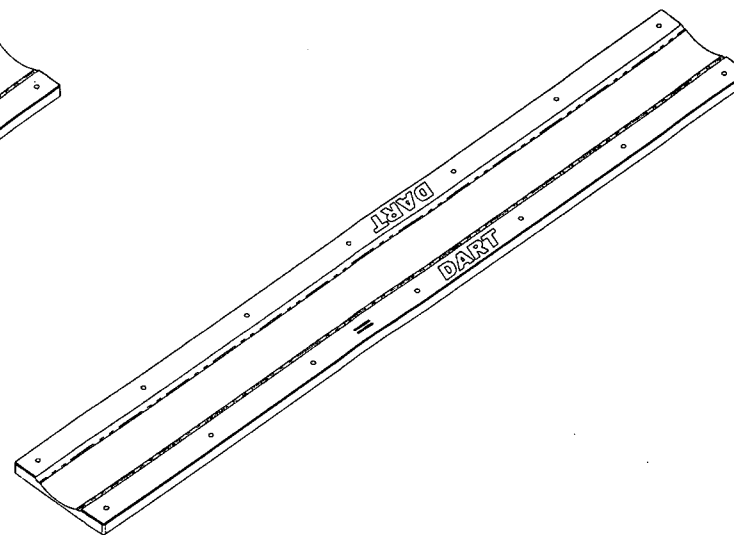
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
19.000	+/-0.010	19.000	—		M-top	ML-08
4.00	+/-0.030	3.994	—		Vern	ML-06
0.050 x 45°	+/-0.010 x +/-0.5°	.040x45°	—			
0.25	+0.030/-0.010	.259	—			

Measured by: <i>mf</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 13/02/21	Date: 13.02.21	Date:

Rev	Date	Change	Revised by	Approved
A	12.07.31	New Issue	KJ	<i>[Signature]</i>
B	12.09.26	Dwg Rev updated	KJ	<i>[Signature]</i>



D3795-1 412 SKI - FWD SECTION



D3795-3 412 SKI - MID SECTION

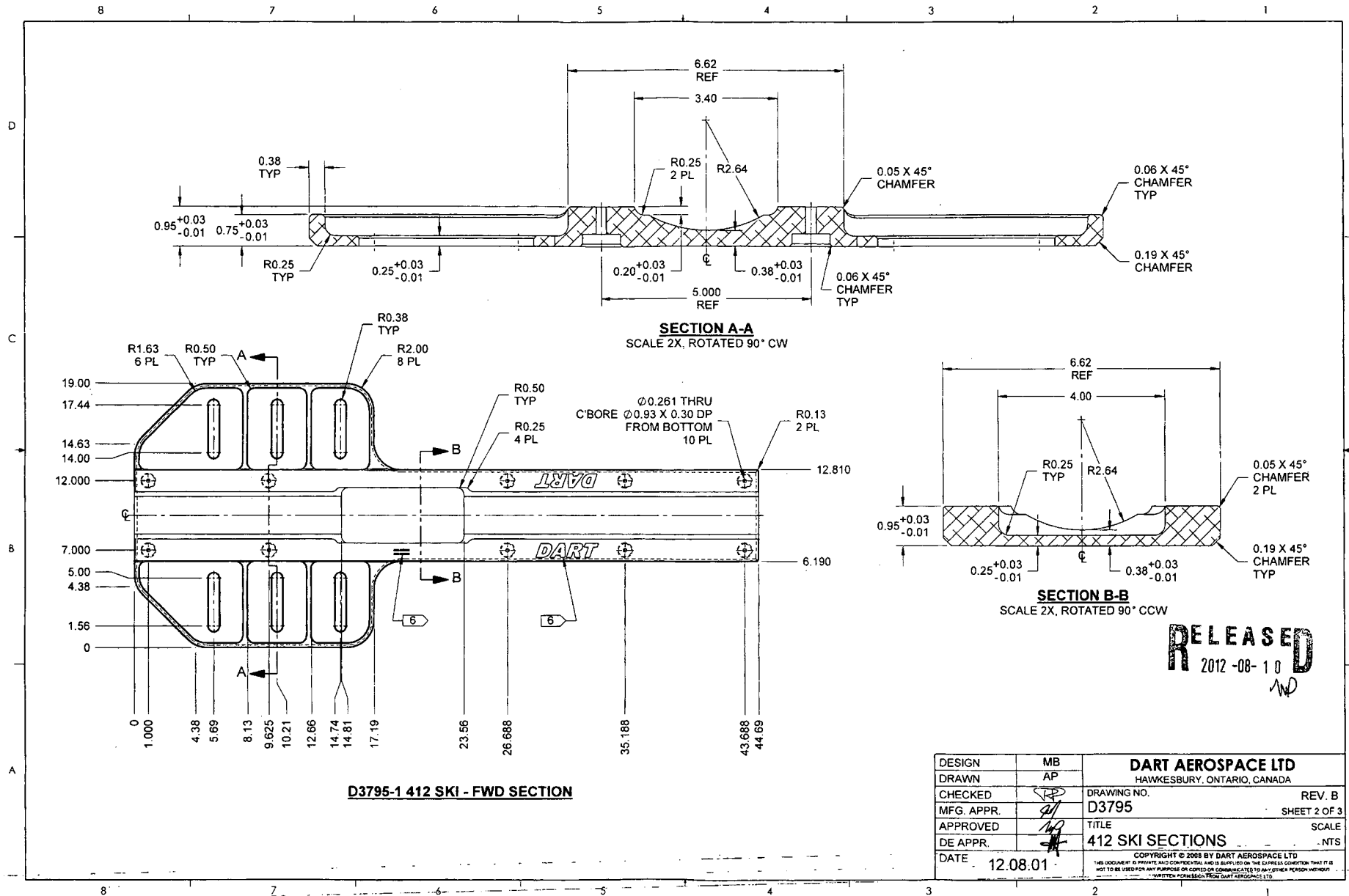
w/o 96958

RELEASED
2012-08-10
MP

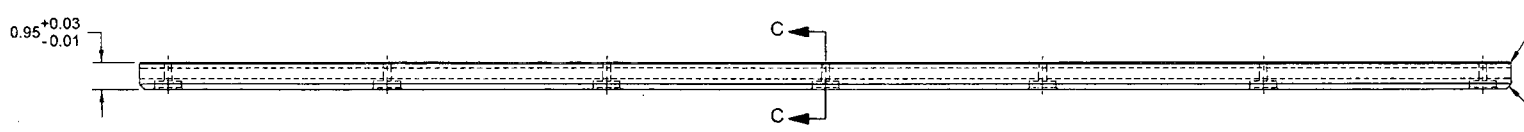
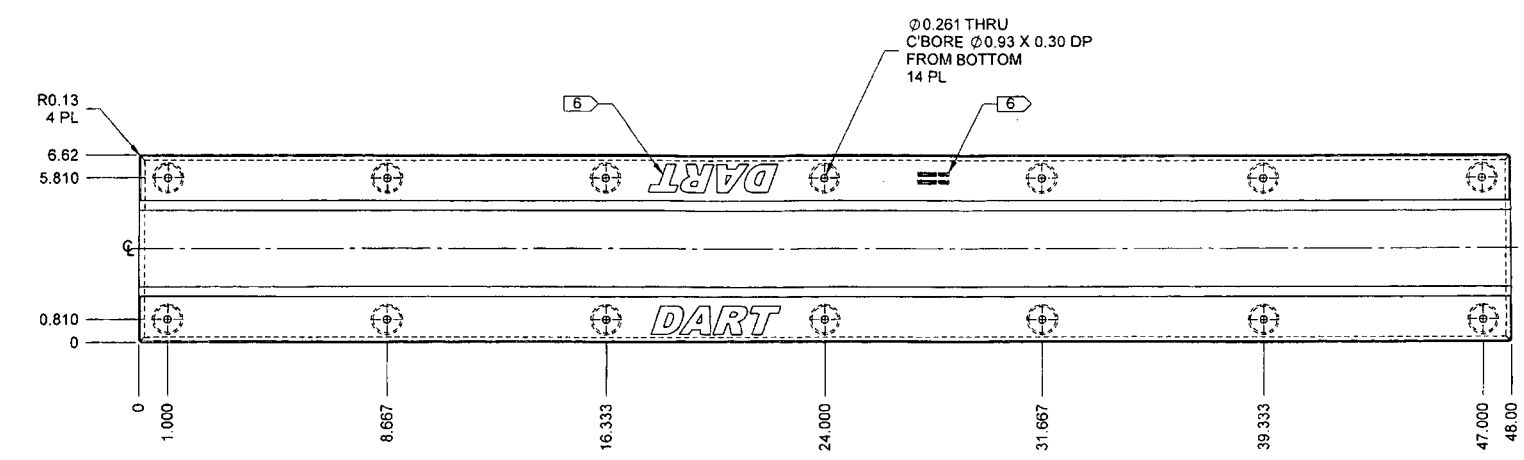
NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF DART SPEC MUHMWB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: - ENGRAVE WITH DART P/N "D3795-X" AND B/N "BXXXXX" USING 0.13 HIGH LETTERS TO MAX DEPTH OF 0.010
- ENGRAVE WITH DART LOGO USING 1.00 HIGH LETTERS TO MAX DEPTH OF 0.012
- 7) WEIGHT: D3795-1 = 9.37 lbs
D3795-3 = 7.88 lbs

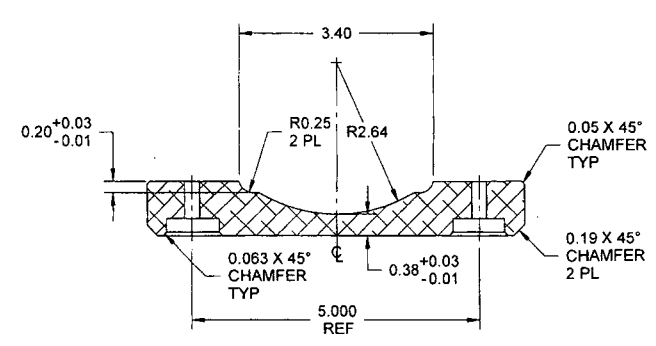
B	CHAMFER WAS 0.31 x 45° NOW 0.19 x 45° (B1-3)	AP	12.08.01
A	NEW ISSUE	MB	08.07.08
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	MP	D3795	SHEET 1 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	412 SKI SECTIONS	NTS
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8 7 6 5 4 3 2 1



D3795-3 412 SKI - MID SECTION



**SECTION C-C
SCALE 2X**

RELEASED
2012-08-10
MPO

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RP	DRAWING NO. D3795	REV. B
MFG. APPR.	RP	SHEET 3 OF 3	
APPROVED	RP	TITLE	SCALE
DE APPR.	CH	412 SKI SECTIONS	NTS
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8 7 6 5 4 3 2 1